

Ship 16/10

Dart Aerospace Ltd.

25

Date: Wednesday, 6/6/2007 2:02:45 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FRAME
Job Number : 32816A
Estimate Number : 10300
P.O. Number :
This Issue : 6/6/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : MACHINED PARTS
Previous Run : 32272A
Written By :
Checked & Approved By : 07.06.07
Comment : Est Rev: A New Issue 05-11-06 JLM
Est: B 06.11.15 waterjet EC

Part Number : D32241
Drawing Number : D3224 REV A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 6/20/2007 Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 5.4600 sf(s)/Unit Total: 43.6800 sf(s)

BH M104921

SAD 07/08/02

2024-T3 .063 thick aluminum sheet

Batch: ~~M104676~~ ~~070616~~

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3224

Dwg Rev: AProg Rev: A

2-Deburr if necessary

SAD 07/07/02 (8)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/02 (8)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

EP 07/09/03 (XB)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 07/08/09 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0706							

Part No: D3224-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: <u>32816A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070616	2.0	wrong grain direction Scrap 2 parts	<i>[Signature]</i> asial2	Replace the 2 parts destroy	<i>[Signature]</i> 07 06 18	<i>[Signature]</i> 07-06-18	<i>[Signature]</i> 07-06-18	<i>[Signature]</i> 07-06-18

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME

Job Number: 32816A

Part Number: D32241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3224

8B 07/10/15

8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
07/10/15 (8)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/10/16 (8)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION:

07/10/16 (8)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57219 PC 7/10/16 (8)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.16 (8)

Job Completion



U 07.10.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

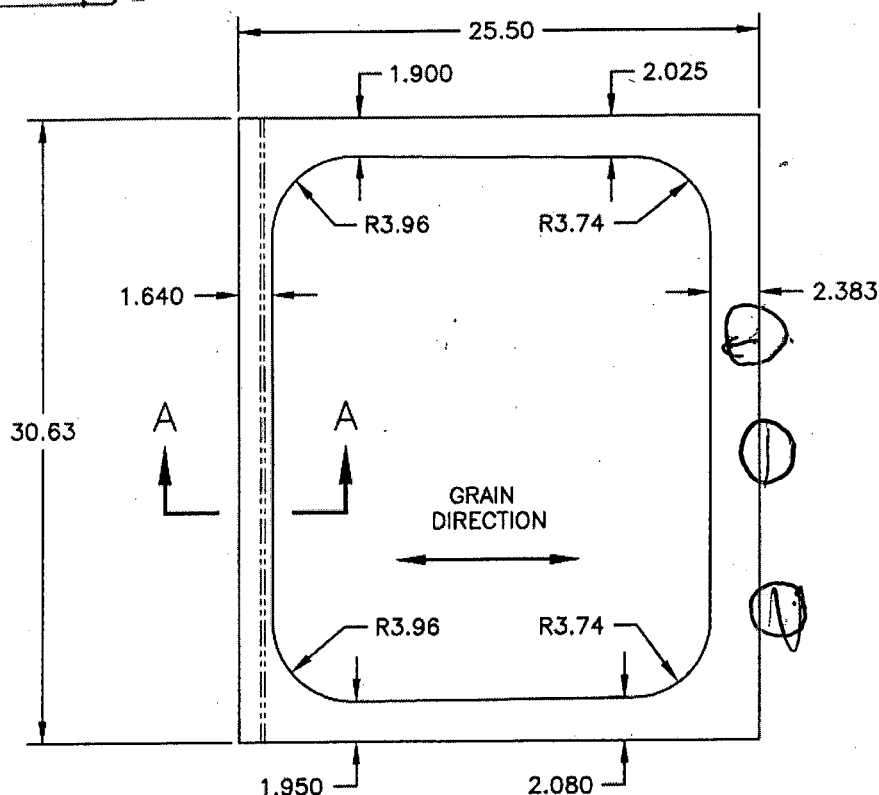
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

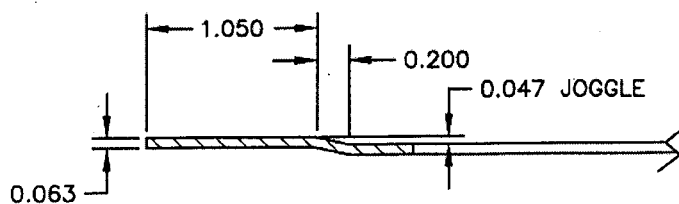


DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3224	REV. A SHEET 1 OF 1
DATE 03.10.21		TITLE FRAME	SCALE NTS
A	03.10.21	NEW ISSUE	

RELEASED
04.02.03 [Signature]



D3224-1



SECTION A-A
SCALE 8:1

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 32816A

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